

Date: Monday, 11/19/2007 4:00:44 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP LEG  
 Job Number : 35817  
 Estimate Number : 11554  
 P.O. Number : N/A Part Number : D30771  
 This Issue : 11/19/2007 S.O. No. : N/A Drawing Number : D3077 REV. B A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : HA Type : SMALL /MED FAB Drawing Revision : B A1  
 Previous Run : 26684 Material : N/A  
 Due Date : 11/23/2007 Qty: 20 Um: Each  
 Written By : [Signature]  
 Checked & Approved By : [Signature]  
 Comment : Est Rev: B 02.11.18 Incorporated D3170-1 IPP KJ  
 Est Rev: C 06-04-27 Manufactured on Water Jet JLM  
 Est Rev: D 06-06-23 Now 6061-T6  
 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



14.7000



Comment: Qty.: 0.6125 sf(s)/Unit Total : 12.2493 sf(s)

Material: M6061-T6 0.080" thick

(M6061T6S.080)

Batch: 106350 HB 07-11-26

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3077

Dwg Rev: A1

HB 07-11-26

(54)

Prog Rev: A1

2-Deburr if necessary HB 07-11-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 07-11-26



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

counts  
5 07/11/26 (x24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D30771

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr to take measurement

*u/a & Hu/26*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*bf 07-11-30*

*(24)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07-11-30*

*(x21)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S Hu/30*

*(x24)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

*07-12-05 24*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07-12-06*

Job Completion



*u 07.12.06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

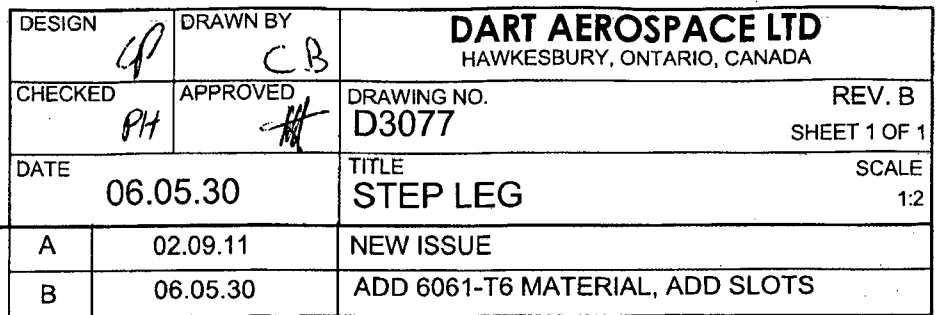
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

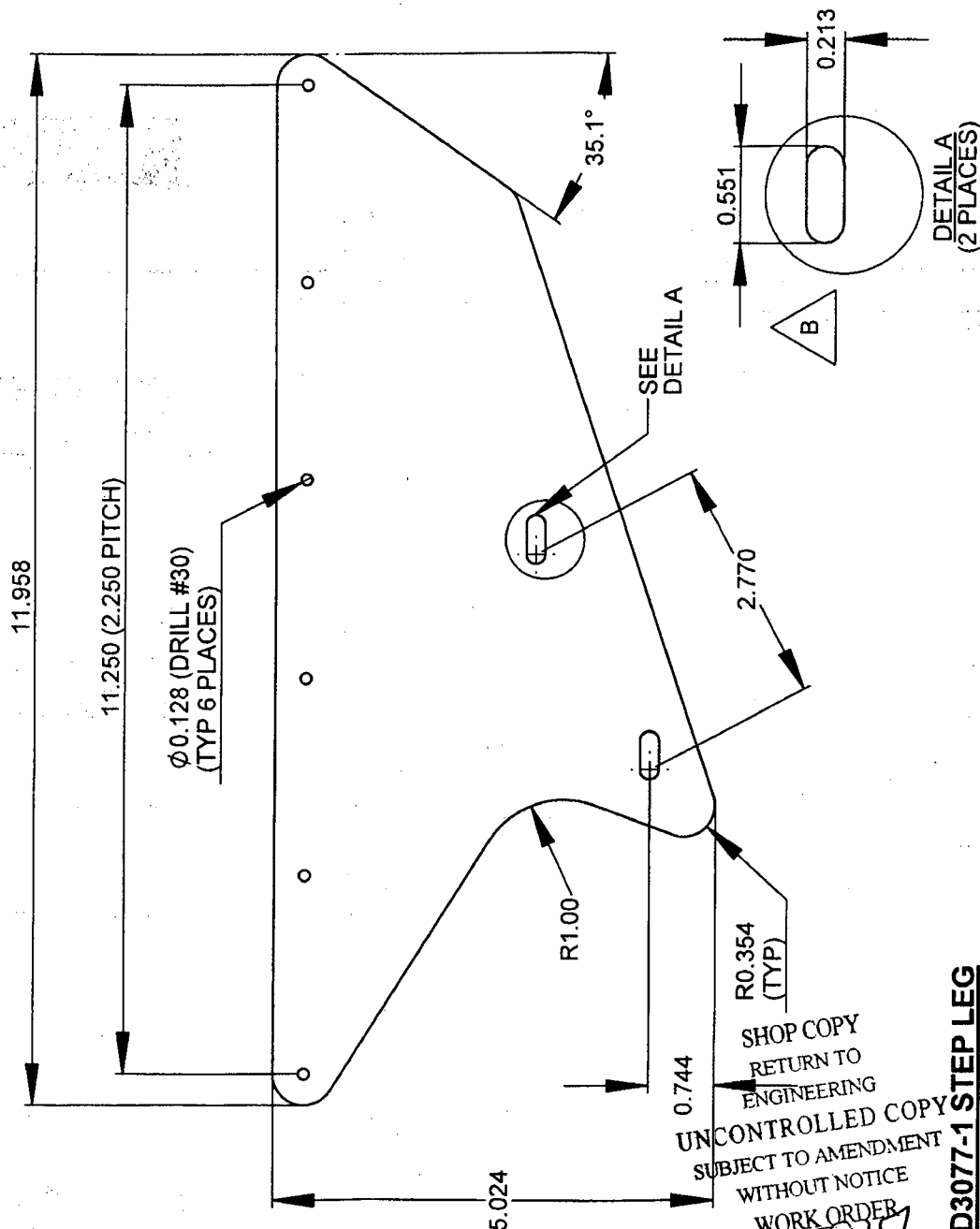
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





06.06.20 



**D3077-1 STEP LEG**

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRT"  
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)  
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

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